

Date: Monday, 5/26/2008 1:09:46 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PANEL-350 AFT CANOPY
<b>Job Number</b> :	39494		
<b>Estimate Number</b> :	13098		
<b>P.O. Number</b> :		<b>Part Number</b> :	D36561
<b>This Issue</b> :	5/26/2008	<b>Drawing Number</b> :	D3656 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	00204
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	38505	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	5/27/2008
<b>Checked &amp; Approved By</b> :	<u>JO 08.5.26</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est. Rev. A 07/12/13 DL verified by:DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 32.0000 sf(s)/Unit Total : 32.0000 sf(s)

GE PLASTICS LEXAN SHEET

batch: M 105494

DL

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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(X1)

**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

DL 08.05.27

3.0	THERMOFORMING	THERMOFORMING MACHINE
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(X1)

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986

Dwg. Rev. A

Folio Rev. A

DL 08.05.27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(X1)

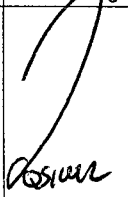
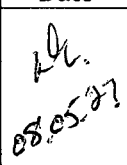
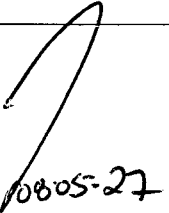

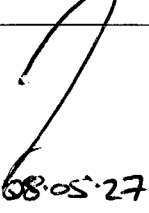
**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

DL 08.05.27  
PTC →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3656-1 PAR #: N/A Fault Category: Prod / Thermforming NCR: (Yes) No DQA: D Date: 08/05/27  
 QA: N/C Closed: D Date: 09/05/20

NCR: 39494		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.27	4	Did not form properly. too much sag.		Scrap & Replace Q+1 m <u>65494</u>	 08.05.27	 08.05.27	 08.05.27	 08.05.27

NOTE: Date & initial all entries

Date: Monday, 5/26/2008 1:09:47 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 39494

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BR 08/05/27 (X1)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

(X1)

1) Trim to Finished Dimensions as per dwg D3656

DL 08.05.27.

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(X1)

Check dimensions to ensure conformity to drawing tolerances.

DL 08.05.27

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 08.05.27 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P.P.R. 38502

JS 08/05/27

(X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28

Job Completion



MF 08-05-27

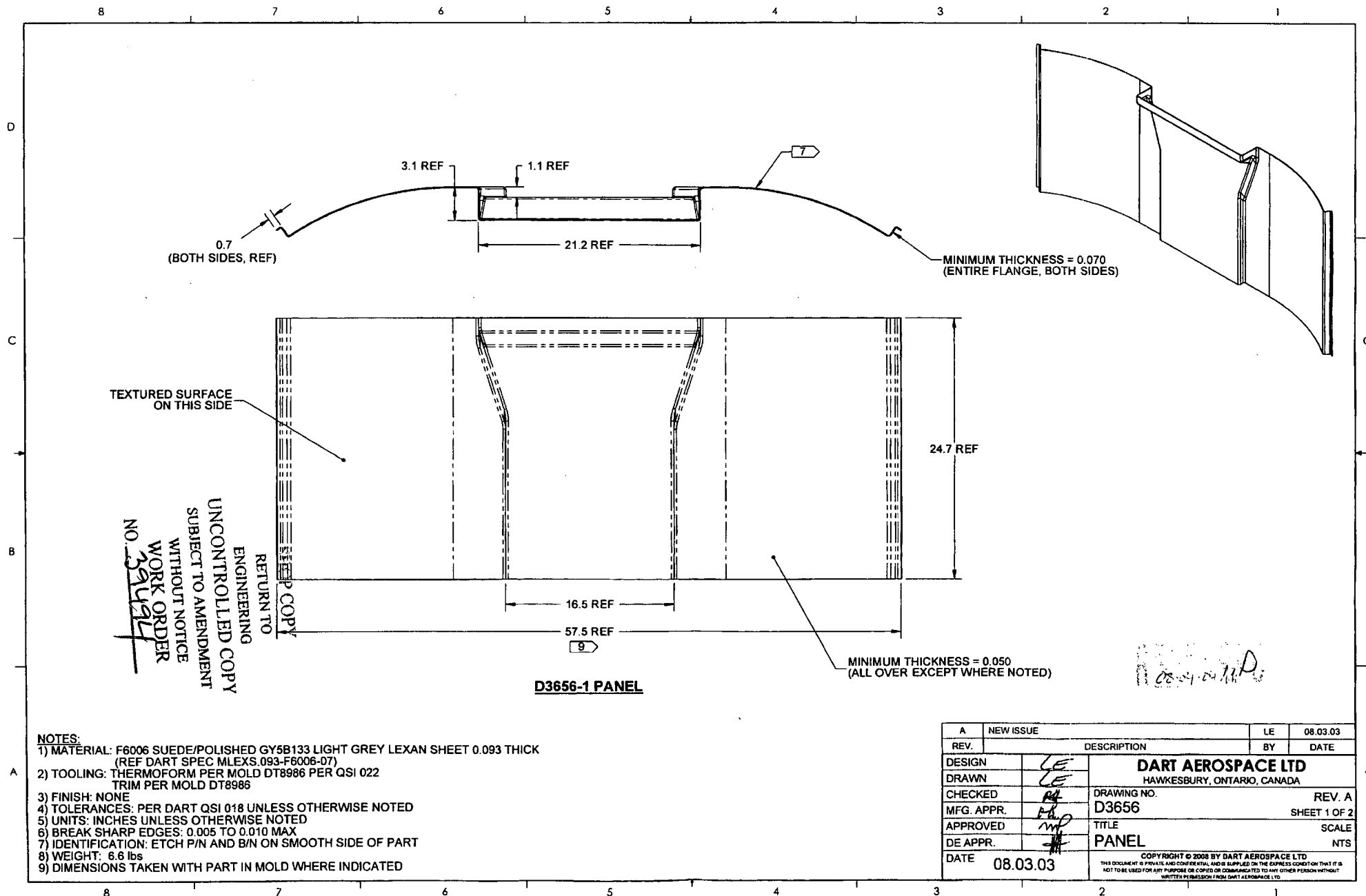
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



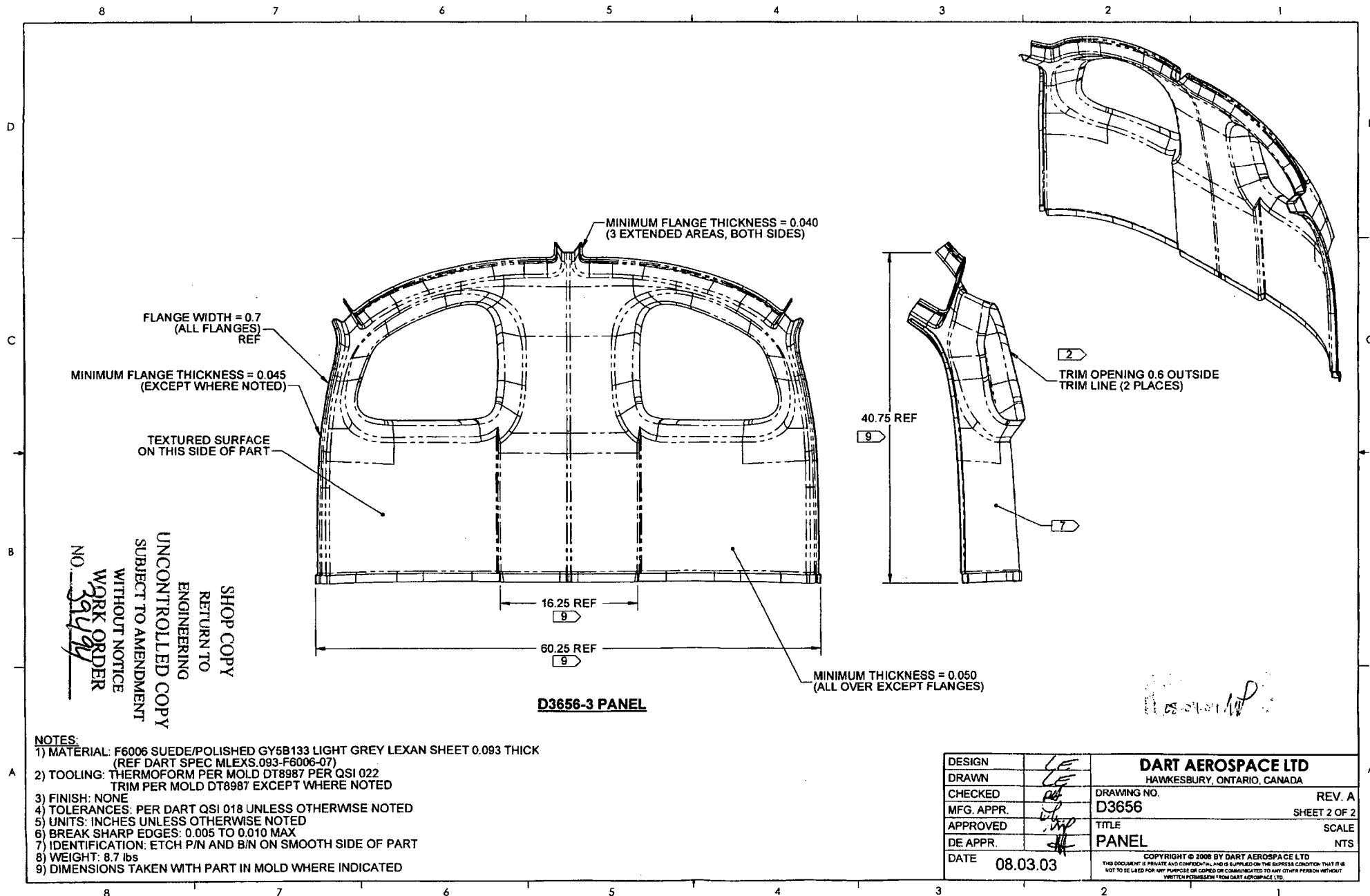
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
  - 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
  - 3) FINISH: NONE
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
  - 8) WEIGHT: 8.7 lbs
  - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. A
MFG. APPR.	MP	D3656	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PANEL	NTS
DATE	08.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	WORK ORDER: 39494
Description: Aft Canoy	Part Number: D3656-1
Inspection Dwg: <u>D3656</u> Rev: <u>A</u>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	<i>DL</i>
Free of visual flaws (bumps, cracks, voids, etc.)	<i>DL</i>

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3656 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7"	0.100"	<u>24.74</u>	✓			
57.5"	0.100"	<u>57.5</u>	✓			
21.2"	0.100"	<u>21.24</u>	✓			
0.7" Flange length	.030"	<u>0.7"</u>	✓			
<u>0.070"</u> Thickness	Min	<u>0.073</u>	✓			

Measured by: *DL*  
Date: 08.05.27

Audited by: *DB*  
Date: 08.05.27

Prototype Approval: *N/A*  
Date:  

Rev	Date	Change	Revised by	Approved
		New Issue		

*DL*